

Tuesday, 10/3/2006 2:50:03 PM  
Kim Johnston

## Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 28829		
Estimate Number	: 10291		
P.O. Number	: N/A	Part Number	: D3183044
This Issue	: 10/3/2006 S.O. No. : N/A	Drawing Number	: D3183 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C1
Previous Run	: 26042	Material	: N/A
Written By	: <u>                    </u>	Due Date	: 10/30/2006
Checked & Approved By	: <u>                    </u> 06/10/03	Qty:	8 Um: Each
Comment	: Est Rev: Pick: A 04.02.18 New issue KJ/DS		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B2000X01500	17-4 SS Bar
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Comment: Qty.: 0.4812 f(s)/Unit Total: 2.8873 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.500x02.000)

Identify for D3183-4

Batch: 119478 1887f 06/10/25

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: (1.500" x 2.000") 5.500" long

06/10/25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3183-4 as per Folio FA322 and Dwg D3183

Identify as D3183-4

2-Deburr

3-Scribe batch number

SD/3L06/11/03

3

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/3L06/11/03

3

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 28829

Part Number: D3183044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7m 06/11/03

8

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3121-21

Bolt

B20704

B 24698 x 6mm

7.0

D3183045

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3183-045 Bearing Ass

B28836 x 10

B 24698 x 6mm

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3183-043 as per Dwg D3183.

SN / J.L

06/11/01

5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/08 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 8412

07/01/08 (5)

07/01/08 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/09 (5)

Job Completion



07/01/09



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28829
<b>Description:</b> Bracket		<b>Part Number:</b> D3183-4
<b>Inspection Dwg:</b> D3183	<b>Rev:</b> C1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

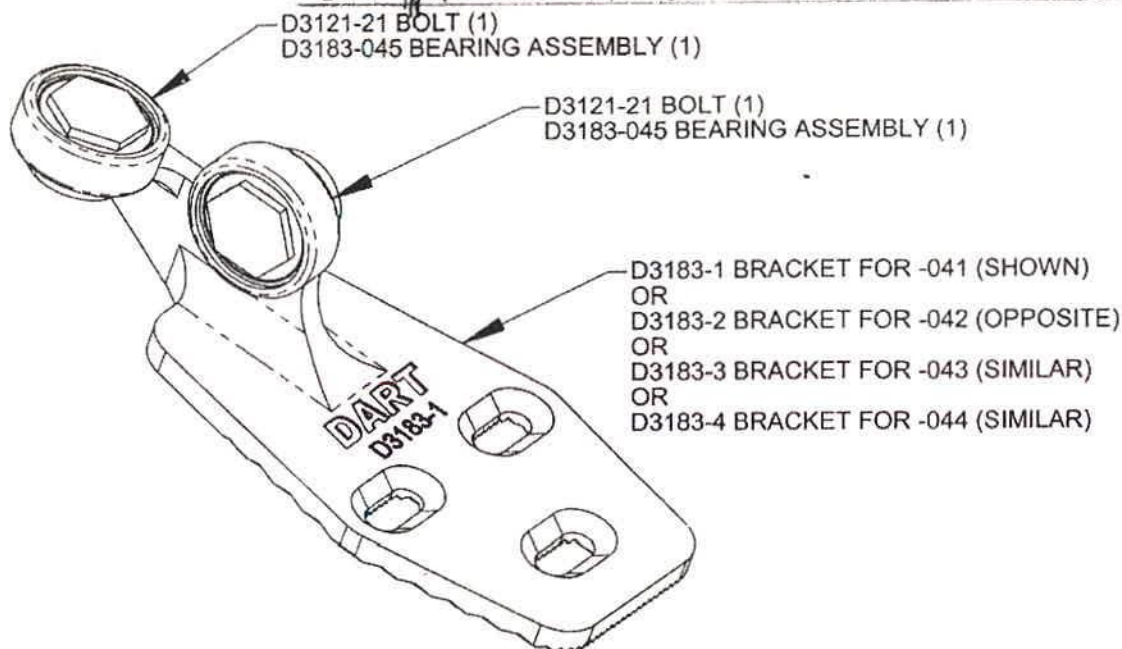
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	R.190	/			
R0.063	+/-0.010	R.063	/			
0.182	+/-0.010	.181	/			
0.070	+/-0.010	.074	/			
0.100	+/-0.010	.102	/			
Ø0.201 x 0.100	+/-0.010	Ø0.201	/			
0.182	+/-0.010	.181	/			
5.32	+/-0.030	5.322	/			
5.036	+/-0.010	5.036	/			
2.120	+/-0.010	2.120	/			
1.290	+/-0.010	1.288	/			
0.365	+/-0.010	.365	/			
0.218	+/-0.010	.215	/			
1.030	+/-0.010	1.028	/			
1.90	+/-0.030	1.887	/			
1.012	+/-0.010	1.012	/			
Ø0.201 x 0.100	+/-0.010	Ø0.201	/			
0.182	+/-0.010	.181	/			
0.786	+/-0.010	.782	/			
Ø0.392	+0.002/-0.000	Ø0.392	/			
R0.19	+/-0.030	R.19	/			
3.954	+/-0.010	3.955	/			
0.162	+/-0.010	.162	/			
R0.19	+/-0.030	R.19	/			
R0.25	+/-0.030	R.25	/			
4.26	+/-0.030	4.262	/			
2.800	+/-0.030	2.800	/			
Calculated dimension						
0.162	+/-0.010	.164	/			
0.615	+/-0.010	.615	/			
0.435	+/-0.010	.435	/			
0.200	+/-0.010	.201	/			
0.381	+/-0.010	.380	/			
0.032	+/-0.010	.032	/			

<b>Measured by:</b> SD	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06.11.01	<b>Date:</b> 02/11/01	<b>Date:</b>	N/A

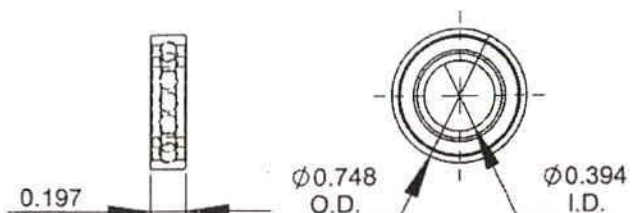
Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-044	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	04.06.15	Dimension 2.800 was 2.080; removed 1.155, 0.36 dimensions	KJ/JLM	
D	06.03.09	Dwg Rev update	KJ/JLM	

**DART**

DESIGN #	DRAWN BY IP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3183</b>	REV. C SHEET 1 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

**RELEASED**  
04 03 01

**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**

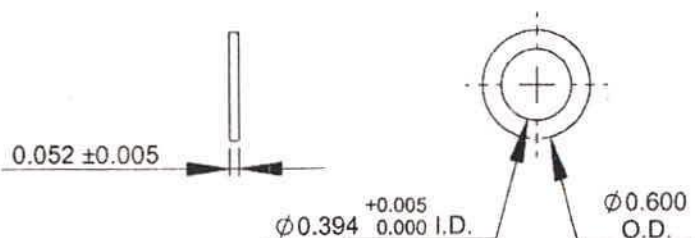


**D3183-5 BEARING:**  
**SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

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NO. 28829



**D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

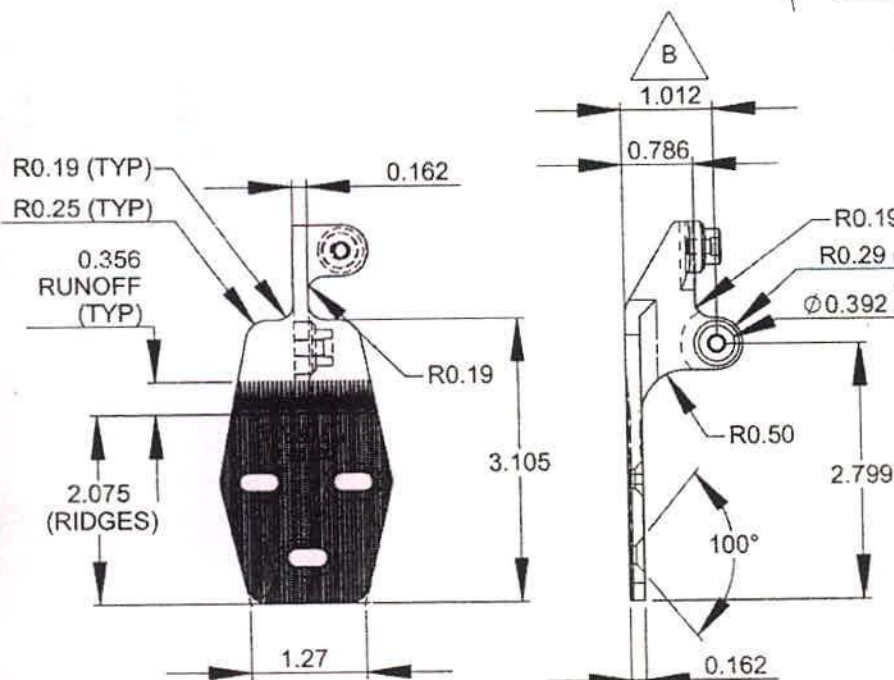
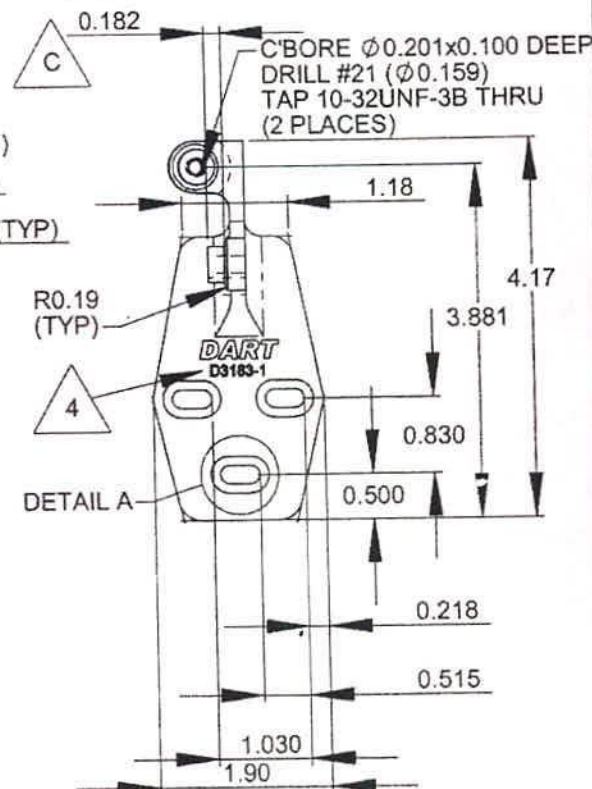
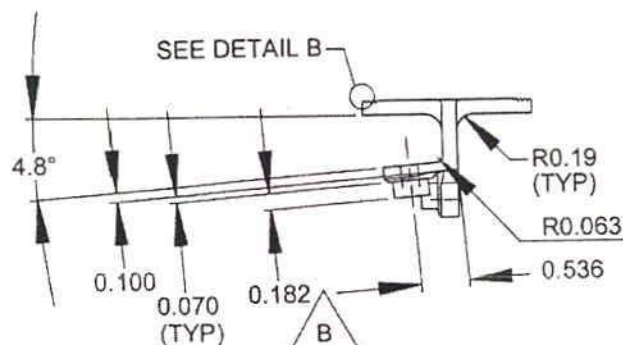
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DATE		D3183	SHEET 2 OF 4
04.02.17		TITLE	SCALE
		BRACKET ASSEMBLY	1:2

**RELEASED**  
04.03.01

**D3183-1 BRACKET SHOWN**  
**D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3  
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

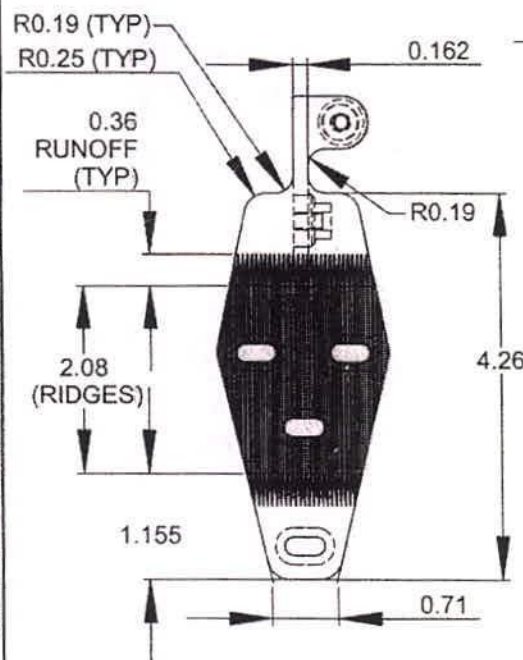
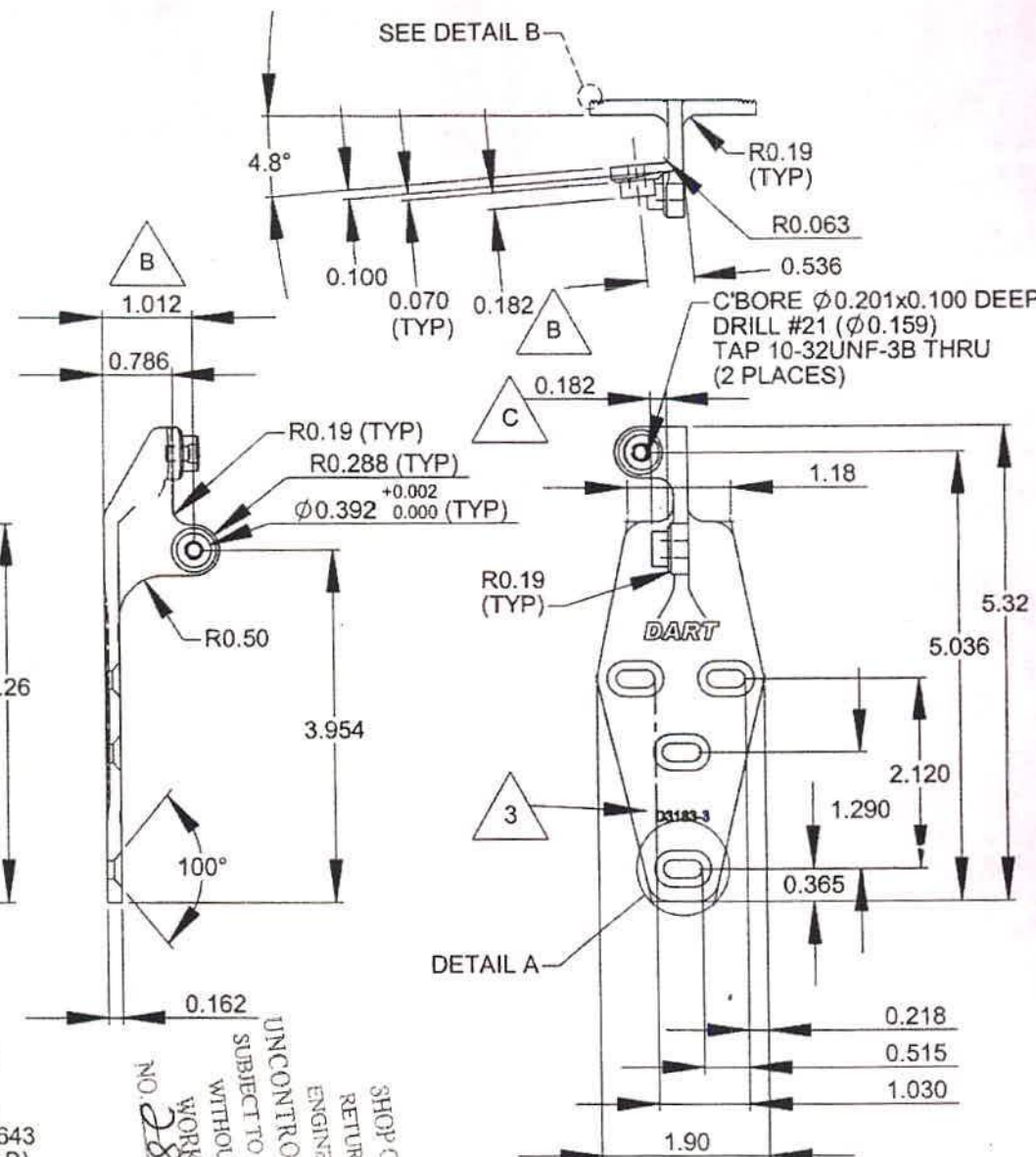
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		D3183	SHEET 3 OF 4
DATE		TITLE	SCALE
04.02.17		BRACKET ASSEMBLY	1:2



D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)  
D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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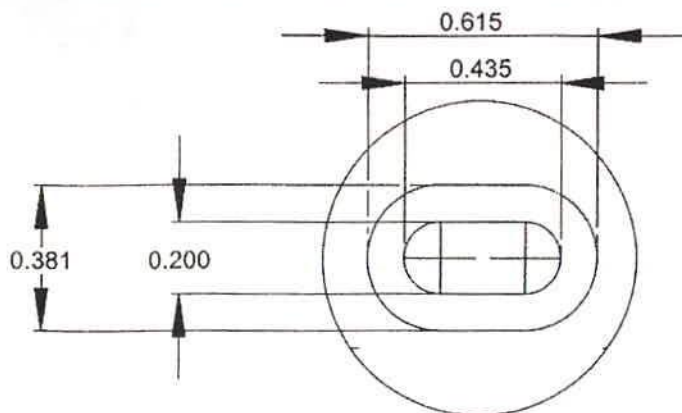
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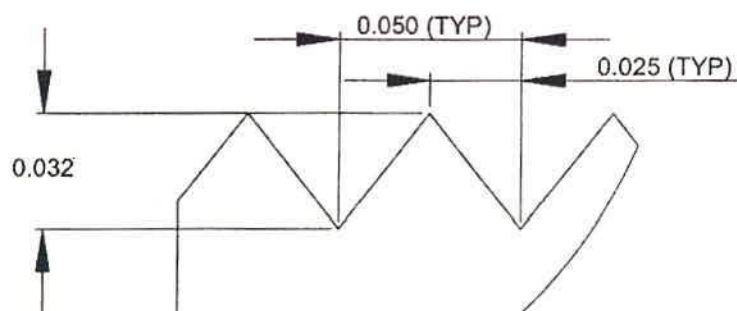


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



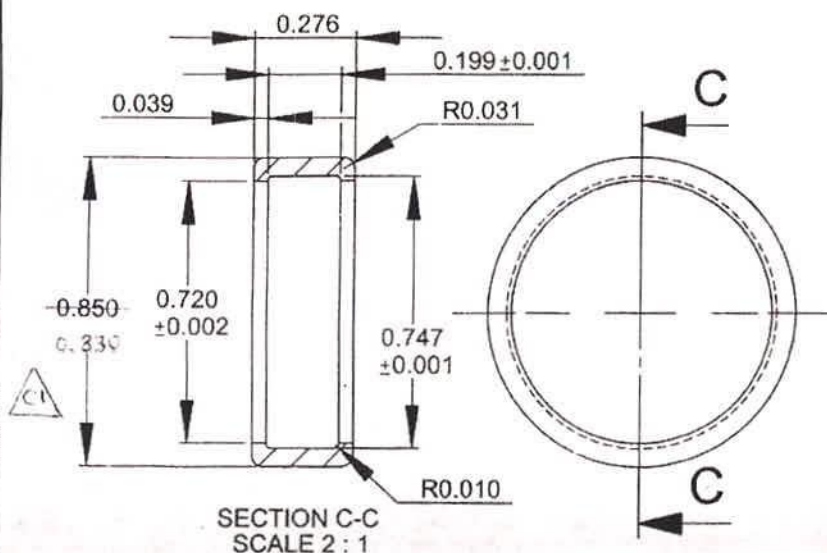
DETAIL A (2 : 1)

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DETAIL B (20 : 1)

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**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP